

Date: Thursday, 11/16/2006 4:25:37 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 29490		
Estimate Number	: 10178		
P.O. Number	: <i>N/A</i>	Part Number	: D25941
This Issue	: 11/16/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2594 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 29165	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/30/2006 Qty: 500 Um: Each
Checked & Approved By	: <i>[Signature]</i> 06/11/17		
Comment	: Est D 02.06.22 Make in Cobra KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s)
Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)
1100-0 (QQ-A-225/1) Ø0.625" Rod
(M5052H32R0.625) or (M6061T6R0.625) Batch *M 102817*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
1-Make as per Dwg D2594-1 and Folio FA262.
2-Break all sharp edges 0.010 max. *GA - ml 06/12/11*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and alodine as per QSI 005 4.1

Q.11

06/12/12

500x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/01/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

FR/K

07/01/10 (500)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MM 07/01/10

(500)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR

MM 07 01 10

(500)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/10

Job Completion



C 07/01/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

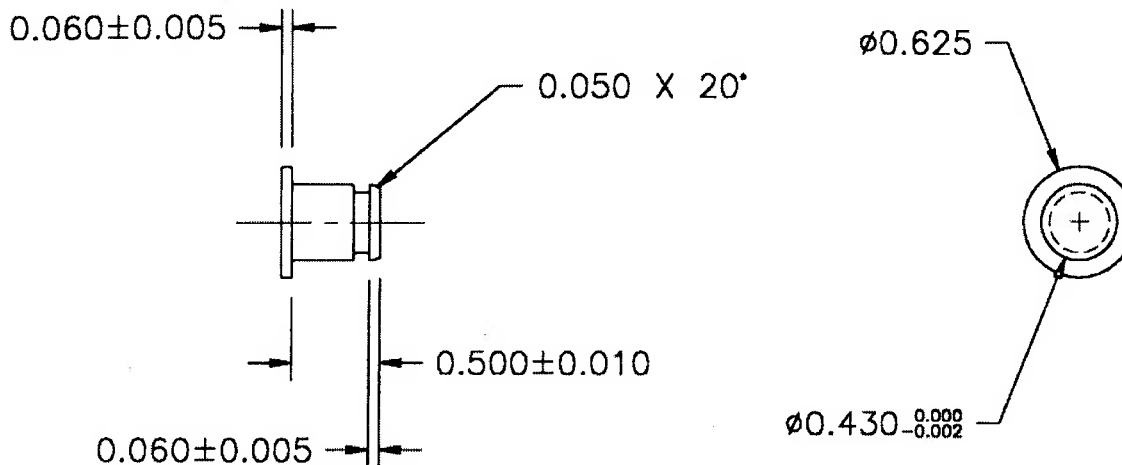
NOTE: Date & initial all entries



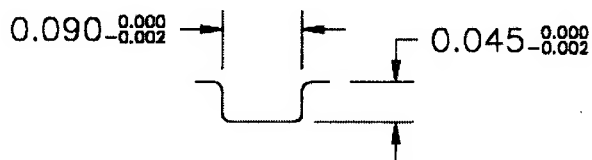
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02.08.26	ADD Powder coat, QSE 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOOLERANCES ARE PER DART QSE 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.S.1) PER QSE 005 4.3

PER QQ-A-225 / 7 (5052)
OR QQ-A-225 / 8 (6061)
OR QQ-A-225 / 1 (1100)
OR QQ-A-200 / 8 (6061)



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SUBJECT TO AMENDMENT
WITHOUT NOTICE

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG
(1) D2594-3 O-RING

WORK ORDER
NO. 29490